

Work Order ID 75194

75194

Page 1

October-18-11 3:27:42 PM

Item ID: D3763-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting Assembly, LH
 Start Date: 18/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3763	Rev B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Large Fab	0.00							
110									
Large Fab	Memo	0.00							
Large Fab	1-make a 0.063" chamfer on D3763-1 fitting before ass'y2-assemble and tack weld as per dwg D3763 using locating pin DT9039 *****look at dwg before assembling parts (LH)***** *****remove pin before welding*****3-weld as per dwg D3763 QSI004 Alum								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
18
9-83

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Item ID: D3763-043 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: End Fitting Assembly, LH
 Start Date: 18/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 12/11/20				2			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2X	0		12/11/20
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	0	12/11/20	

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Item ID: D3763-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Fitting Assembly, LH
Start Date: 18/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
-----	---	------	--	--	--	--	--	--	--

160

Packaging

Memo

0.00

Packaging

170	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

170

QC

Memo

0.00

Quality Control

12/11/21 (2)

12/11/22 JF

MF
12-11-21

Picklist Print

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Work Order ID: 75194

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Parent Item: D3763-043

D3763-043

Parent Item Name: End Fitting Assembly, LH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3763-1		Manufactured	No			110	Each	12.0000	2	4			
D3763-1									**				
End Fitting													
		85809x4											
				<u>Location</u>									
				WA				12					
					74863			12					
D3763-5		Manufactured	No			110	Each	17.0000	1	2			
D3763-5									**				
Tube													
				<u>Location</u>									
				WA030				17					
					42734			7					
					54380			10					

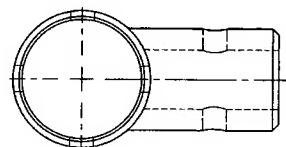
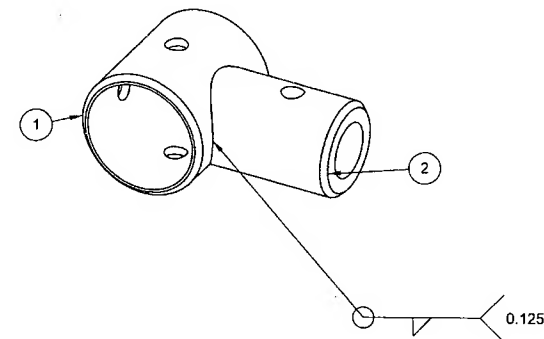
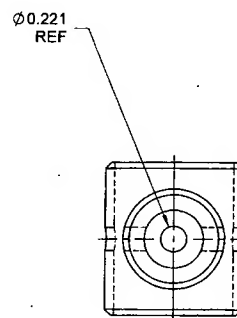
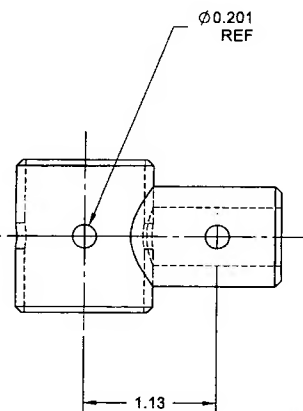
EL 12-11-19

EL 12-11-19

2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75194

M.L.J
11/10/18



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

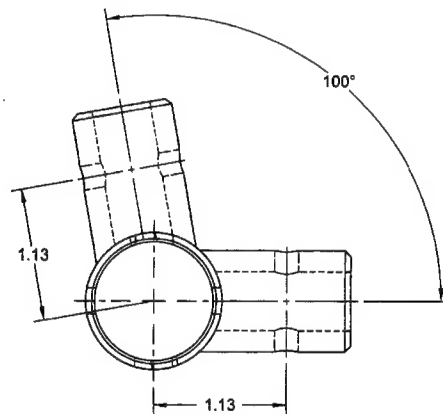
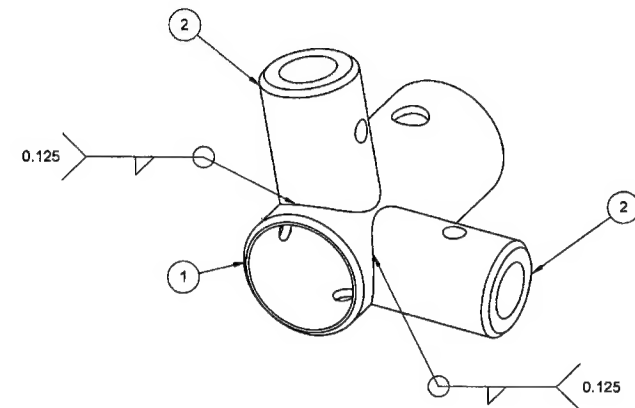
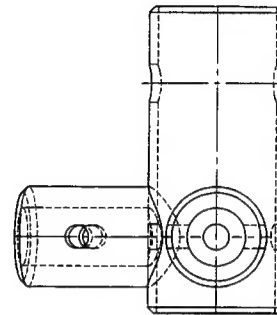
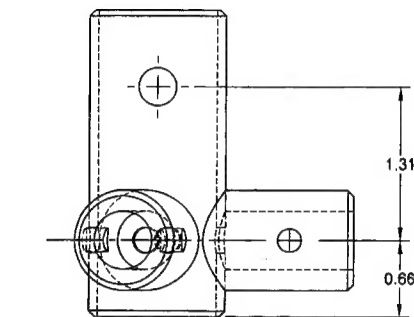
RELEASED
08.07.10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3763 END FITTING <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			
		REV. B	SHEET 1 OF 9
		SCALE	NTS

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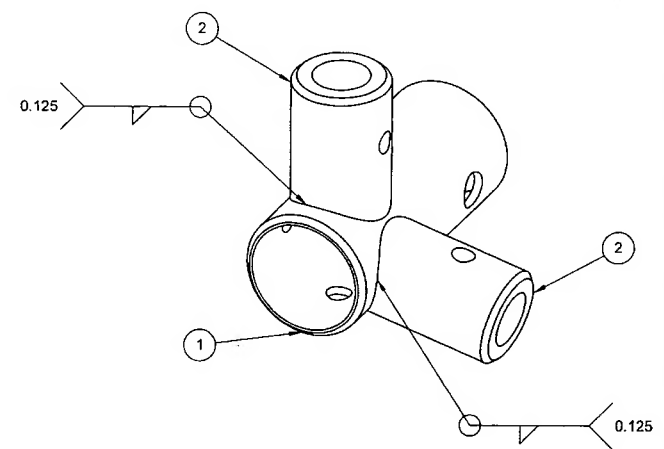
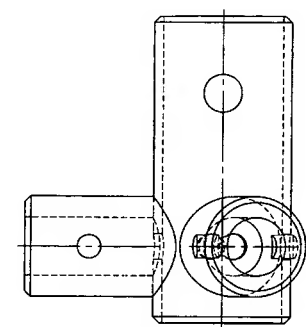
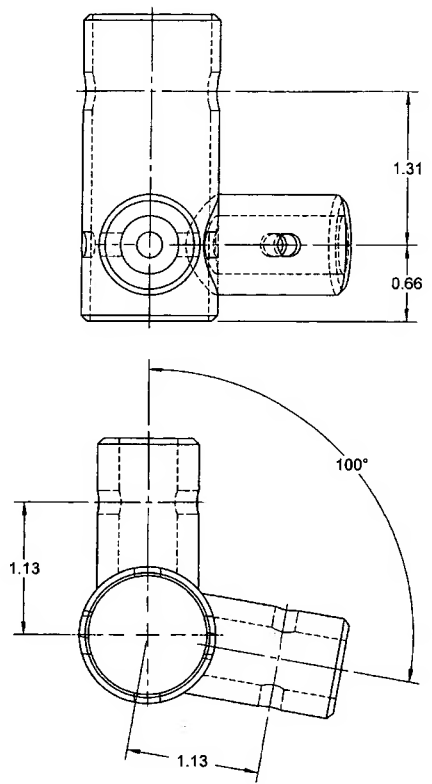
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH**RELEASED**
08-01-2010**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3763	SHEET 2 OF 9
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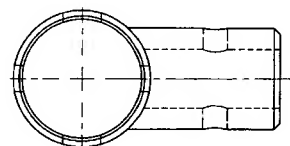
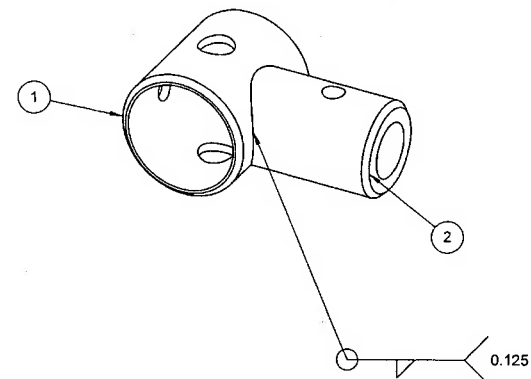
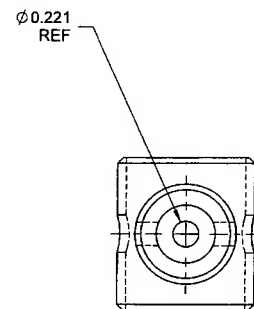
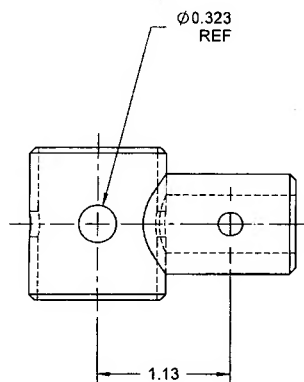
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

D3763-044 END FITTING ASSY, RH

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

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MFG. APPR.	HS	SHEET 3 OF 9	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1

D3763-045 END FITTING ASSY

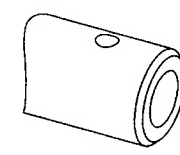
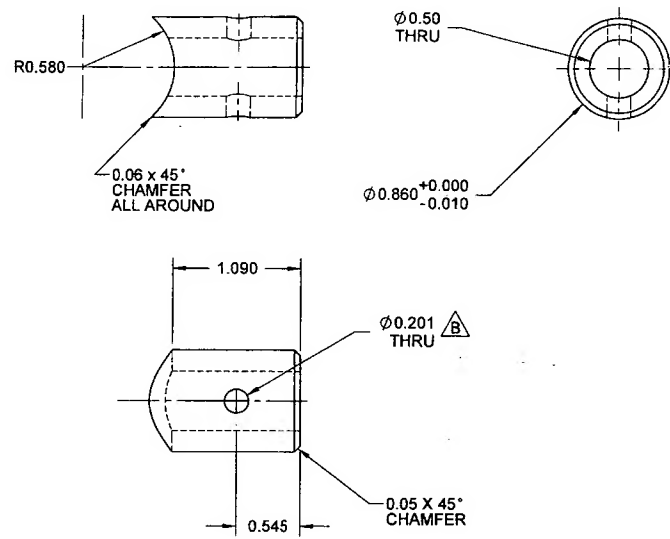
RELEASED
08-07-10 M/A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

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MFG. APPR.		TITLE END FITTING	SHEET 4 OF 9
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D3763-1 FITTING

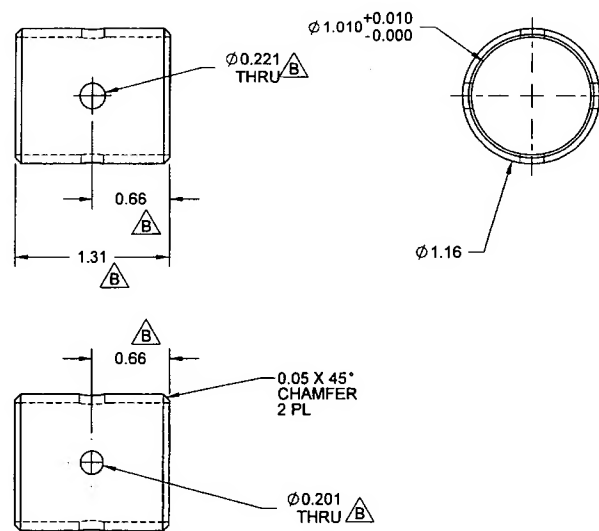
RELEASED
108-07-10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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MFG. APPR.		D3763	SHEET 5 OF 9
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**D3763-3 TUBE****NOTES:**

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

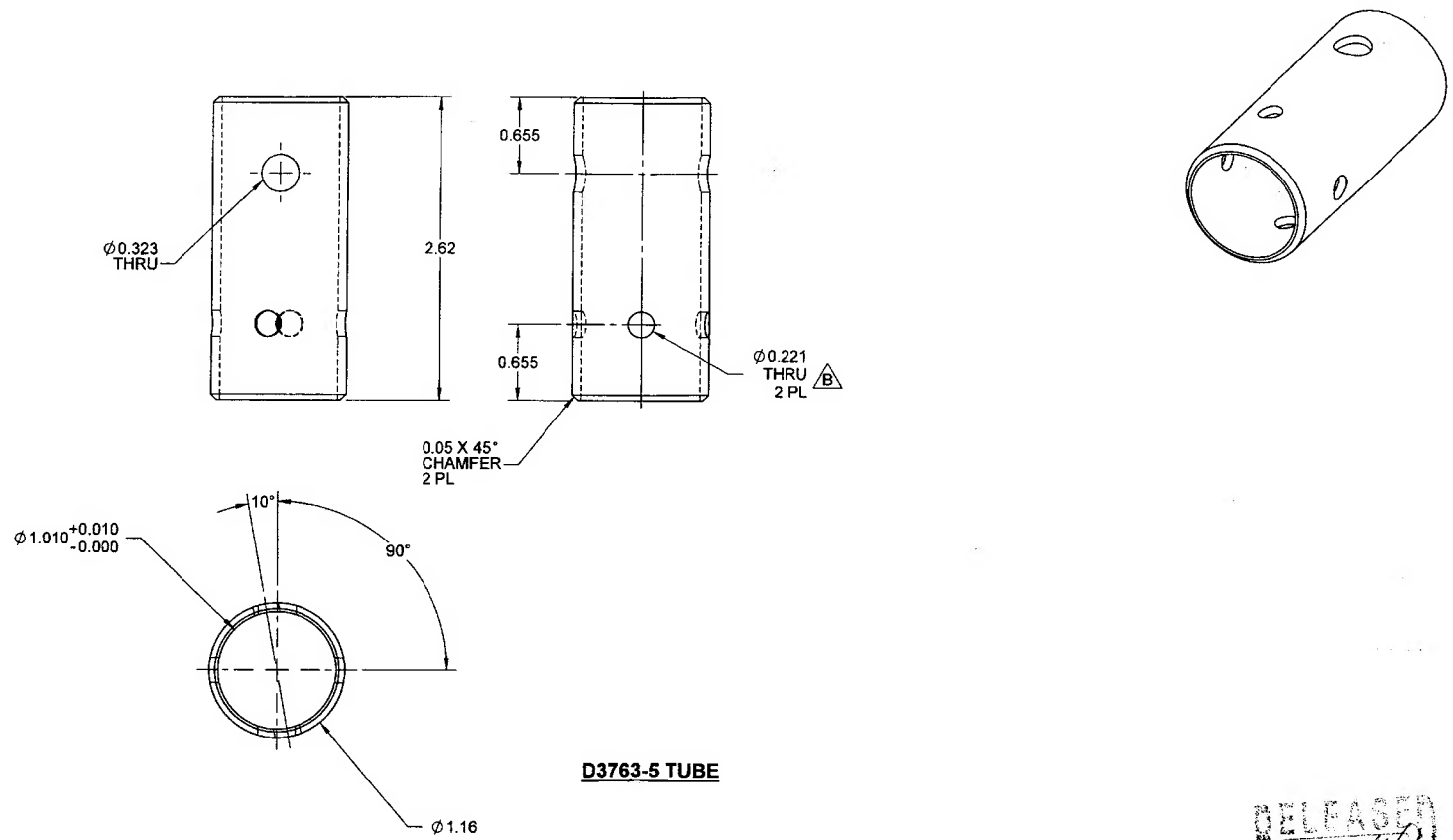
6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

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MFG. APPR.	<i>[Signature]</i>	D3763	SHEET 6 OF 9
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DE APPR.	<i>[Signature]</i>	END FITTING	NTS
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RELEASED
08.07.10

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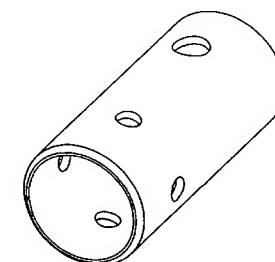
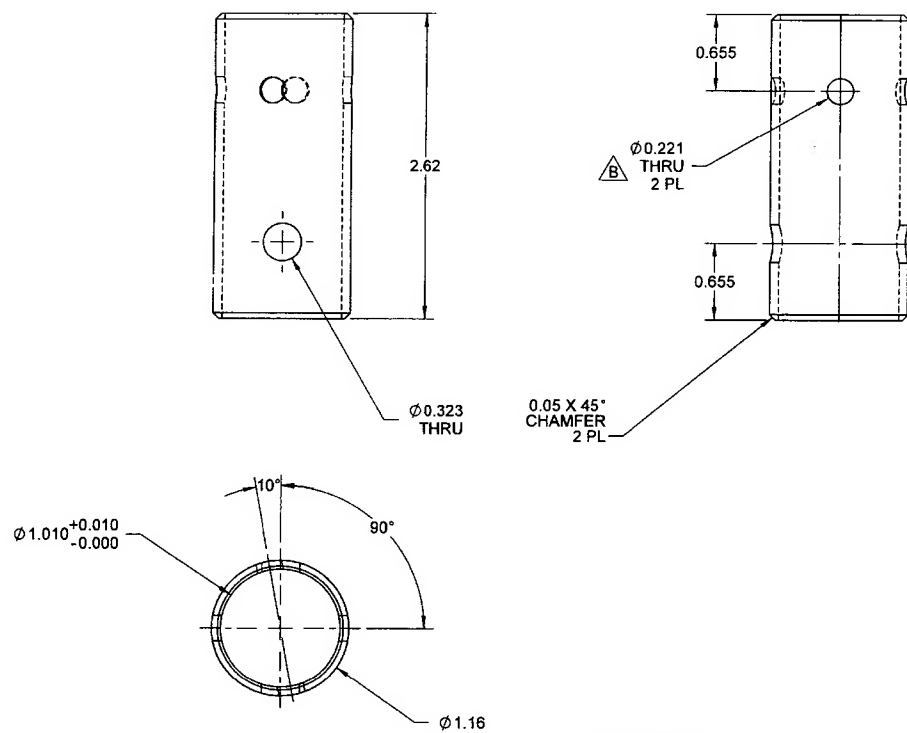
D3763-5 TUBE

RELEASED
15 OCT 1974

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs





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DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3763	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	END FITTING	NTS
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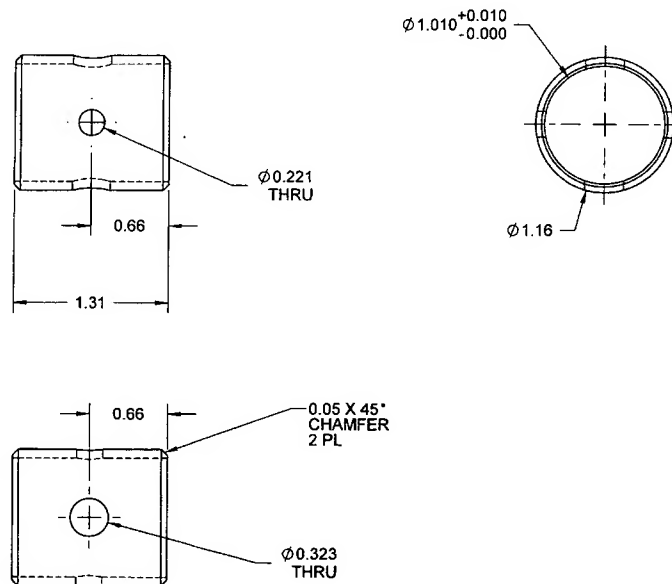


D3763-6 TUBE

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 8 OF 9
APPROVED		TITLE	SCALE
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

75194



D3763-7 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
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